

# DOWLEX™ GM 8480F

Linear Low Density Polyethylene Resin

The Dow Chemical Company

## Message:

DOWLEX™ GM 8480F Polyethylene Resins suitable for cast stretch film applications with superior extensibility while maintaining good puncture and load retention.

Main Characteristics

Superior extensibility

Good puncture and load retention

General Information			
Additive	Anti-caking agent (0 ppm)		
Agency Ratings	FDA FCN 741		
	Europe No 10/2011		
Forms	Particle		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	0.917	g/cm <sup>3</sup>	ASTM D792
Melt Mass-Flow Rate (MFR) (190°C/2.16 kg)	3.0	g/10 min	ASTM D1238
Films	Nominal Value	Unit	Test Method
Film Thickness - Tested	20	µm	
Film Puncture Resistance	22.9	J/cm <sup>3</sup>	Internal method
Tensile Strength			ASTM D882
MD: Yield	9.97	MPa	ASTM D882
TD: Yield	8.49	MPa	ASTM D882
MD: Fracture	32.3	MPa	ASTM D882
TD: Fracture	18.9	MPa	ASTM D882
Tensile Elongation			ASTM D882
MD: Fracture	320	%	ASTM D882
TD: Fracture	360	%	ASTM D882
Dart Drop Impact	340	g	ASTM D1709A
Elmendorf Tear Strength			ASTM D1922
MD	210	g	ASTM D1922
TD	360	g	ASTM D1922
Thermal	Nominal Value	Unit	Test Method
Melting Temperature (DSC)	121	°C	Internal method
Extrusion instructions			

Fabrication Conditions for Cast Film:  
Machine: 5 layer cast film extrusion line  
Monolayer Film (0.8mil)  
Screw Size: 2 inch - 30:1 L/D  
Screw Size: 2.5 inch - 30:1 L/D  
Screw Size: 2.5 inch - 30:1 L/D  
Screw Size: 2.5 inch - 30:1 L/D  
Screw Size: 2 inch - 30:1 L/D  
Die Gap: 20 mil  
Melt Temperature: 270 °C  
Output: 400 lbs/hr  
Line Speed: 600 ft/min

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